

Work Order ID 52233

Monday, September 21, 2009 11:42:09 AM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID: F3

Stop



Item Name: Bearpaw

Start Date: 9/22/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/6/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

PL

Date: *09-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

802/1/26

Handwritten signature and date: 09/11/03

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

Handwritten date and initials: 9/10/19 Ex SP

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Handwritten date and initials: 802/1/26

Handwritten signature and date: 9/10/19

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Item ID: D206-559-013

Accept

Revision ID: F3

Item Name: Bearpaw

Start Date: 9/22/2009 Start Qty: 8.00

Required Date: 10/6/2009 Req'd Qty: 8.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180



Packaging

Packaging

Packaging

Memo

Identify and pack for shipping as per PPPD206-559-013 Location: _____

N/A

0.00

0.00

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

09/14/26 (8)

09/11/30 (8)

09-11-30 (8)

Picklist Print

Page 1

Monday, September 21, 2009 11:42:08 AM

Work Order ID: 52233

Parent Item: D206-559-013RevF3

Parent Item Name: Bearpaw


Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4 		Purchased	No				Each	7,906.000	96.0000			
Nut												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

7906

107499

5

108145

4

110450

1

110507

184

111827

5996

112314

1651

15924

0

7690

24

8182

41

112314

sf

AN4-15A-12x



Bolt

Purchased

No

170

Each

616.0000

96.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

616

107737

8

108077

1

108868

7

109148

18

110399

8

111295

574

111295

9/11/09

(8x) sf

Picklist Print

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Monday, September 21, 2009 11:42:08 AM

Work Order ID: 52233



Parent Item: D206-559-013RevF3



Parent Item Name: Bearpaw

Start Date: 9/22/2009

Required Date: 10/6/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-17A	12x	Purchased	No			170	Each	2,068.000	96.0000			



S
Bolt



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2068	
105653	5	
107321	58	
109061	5	
111758	1000	
112314	1000	

111758 9/10/19 8x SP

Picklist Print

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Work Order ID: 52233

Parent Item: D206-559-013RevF3

Parent Item Name: Bearpaw

Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416	24	Purchased	No			170	Each	7,829.000	192.0000			

Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	7829
102929	2
105906	4
106277	2
107321	23
107939	114
108161	553
108827	31
109249	69
110523	340
111279	101
111916	1995
112314	4595
16941	0

112314 SP

D2182BRevC

Manufactured No

170

f

228.2300

20.8000

Rubber Cushion

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	228.23
28042	7.33
30872	0.33
45405	220.57

45405

9/10/19

SP

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Shop Packet Print

Page 3

8
fb

cut (6) at 5.00" as per dwg
per kit
(B2182.B050)

Masser 9/10/19

Picklist Print

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Work Order ID: 52233



Parent Item: D206-559-013RevF3



Parent Item Name: Bearpaw

Start Date: 9/22/2009

Required Date: 10/6/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2274RevF <i>12x</i>		Manufactured	No			170	Each	624.0000	96.0000	<i>✓</i>		
<i>S</i>												

tb Radius Block

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	624	
22494	0	
23174	0	
36624	17	
38173	6	
42099	34	
43838	62	
47796	32	
50227	149	
51425	324	

D2432RevF3 *2x*

Manufactured No

170

Each

1.0000

16.0000



tb 206 (24") Bearpaw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	1	
30576	1	

51425 sp

B53432 09/14/26

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Monday, September 21, 2009 11:42:08 AM

Work Order ID: 52233

Parent Item: D206-559-013RevF3

Parent Item Name: Bearpaw

Comments:

Start Date: 9/22/2009

Required Date: 10/6/2009

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2438RevC	6x 6x	Manufactured	No			170	Each	53.0000	48.0000			
<div style="display: flex; justify-content: space-between;"> <div> <p>Clamp</p> <p>☆</p> </div> <div> <p>Warehouse</p> <p>Location</p> <p>Main Warehouse</p> <p>ST</p> <p>46113</p> </div> <div> <p>Loc Qty</p> <p>53</p> <p>53</p> </div> <div> <p>Loc Code</p> <p></p> </div> </div>												

D2529RevE	12x	Manufactured	No			170	Each	470.0000	96.0000			
-----------	-----	--------------	----	--	--	-----	------	----------	---------	--	--	--

Washer												
<div style="display: flex; justify-content: space-between;"> <div> <p>Warehouse</p> <p>Location</p> <p>Main Warehouse</p> <p>ST</p> <p>51406</p> </div> <div> <p>Loc Qty</p> <p>470</p> <p>470</p> </div> <div> <p>Loc Code</p> <p>(36)</p> </div> </div>												

D2732RevB1	16 @ 5.00"	Manufactured	No			170	f	146.4430	20.8000			
------------	------------	--------------	----	--	--	-----	---	----------	---------	--	--	--

Rubber Extrusion												
<div style="display: flex; justify-content: space-between;"> <div> <p>Warehouse</p> <p>Location</p> <p>Main Warehouse</p> <p>ST</p> <p>38509</p> <p>43118</p> </div> <div> <p>Loc Qty</p> <p>146.443</p> <p>24.62</p> <p>121.823</p> </div> <div> <p>Loc Code</p> <p></p> </div> </div>												

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Shop Packet Print

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



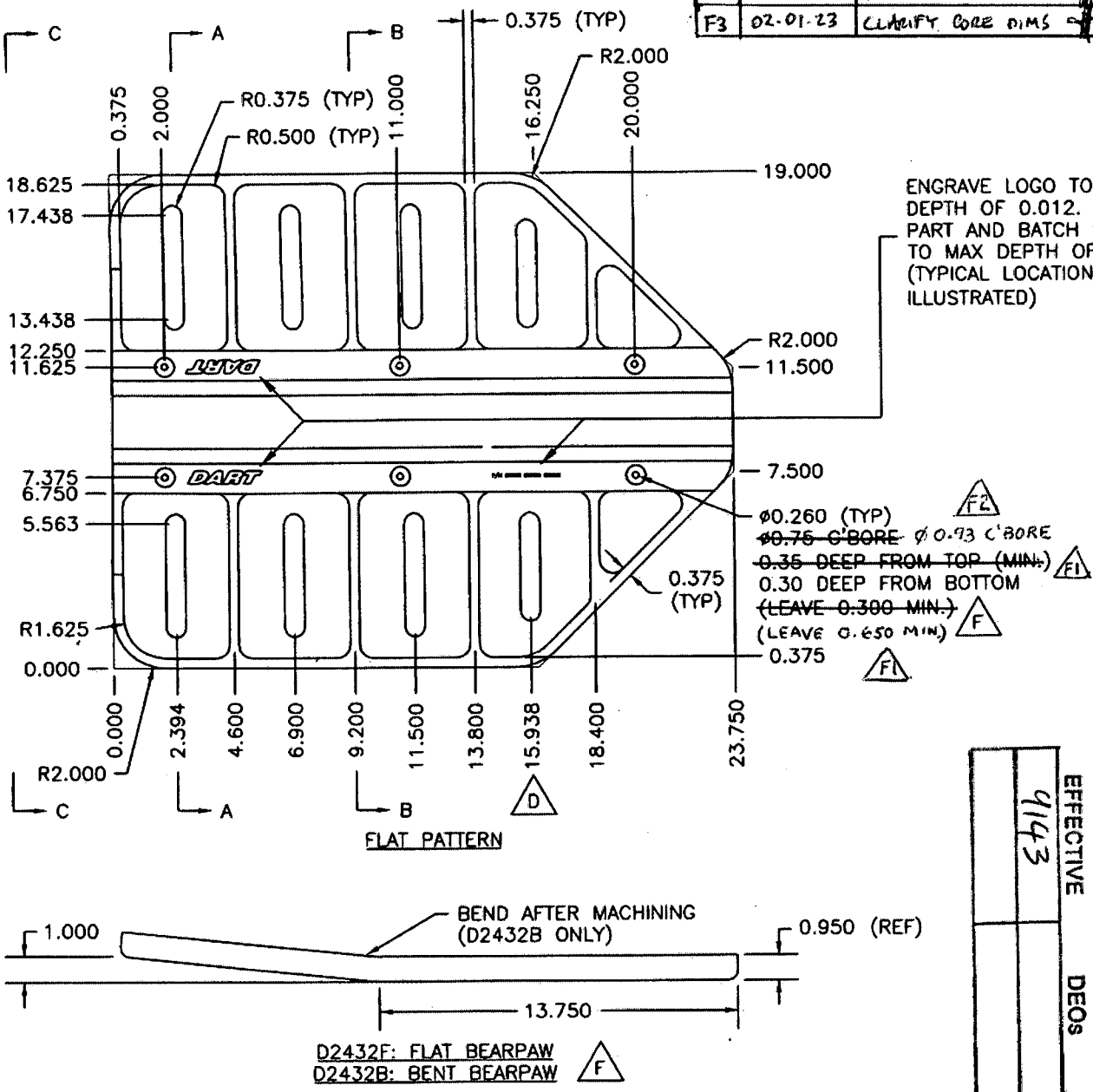
50033

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. F
KE	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
RM		D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY BORE DIMS RF

RELEASED
98.06.17 KG

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)



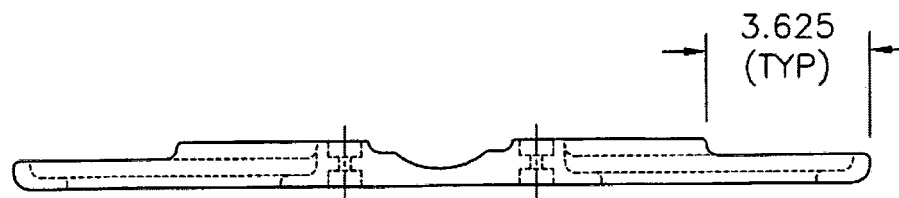
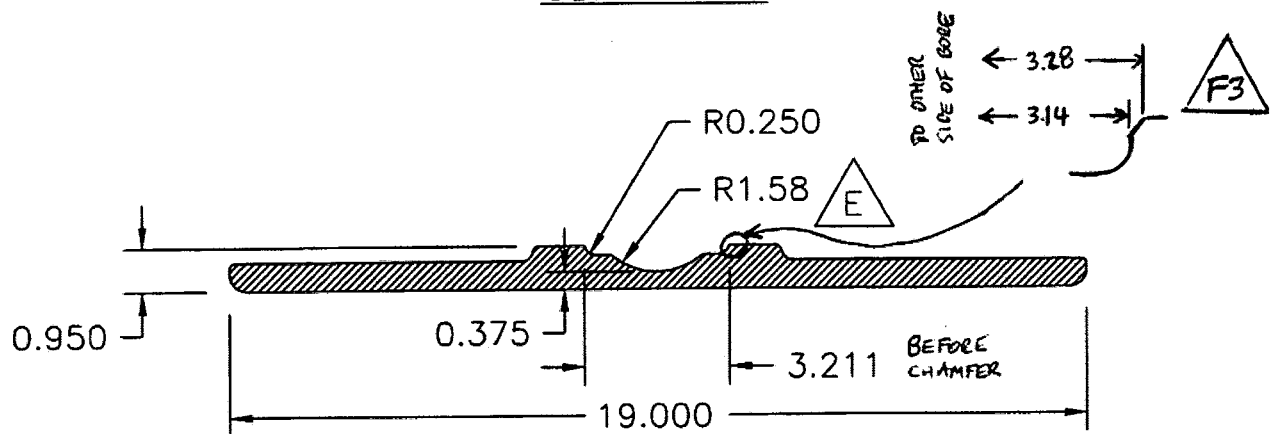
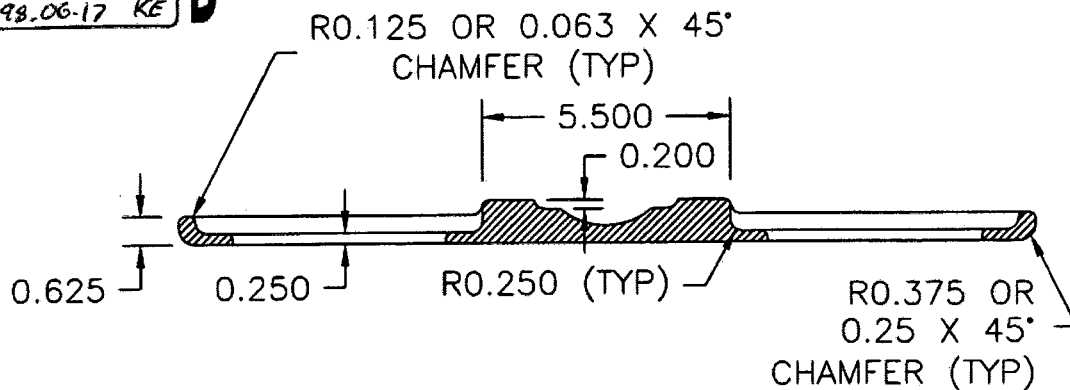
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O 52233



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED
98.06.17 KE



REFERENCE

DART AEROSPACE LTD.

REFERENCE ONLY

D206-559

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						2	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-15A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
				8	12		NAS1149D0463J	WASHER
2		2					QS200M44S	CLAMP

52233

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Revision: K

Date: 09.11.16